Work Ord August 4, 2010			,										Page 1
Item ID: Revision ID:	D206-64	12-441			Accept					Setup	Start		
Item Name:	Replacem	nent Skidtube									Stop		
Start Date: Required Date:	8/04/10 8/1 <u>6</u> /10	Start Qty: Req'd Qty:				Cust Item l Customer:	ID:						
Reference:												*****	
Approvals:	Process	s Plan:		Date: _/6_8-	04 Tooling:	D	ate:			Run	Start Stop		
	QC: _			Date:	SPC (Y/N):	D :	ate:				Stop		
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
Draw Nbr		Revision Nbr										· · · · · · · · · · · · · · · · · · ·	
D2650		Rev F								•			

CHG002

0.00

0.00

Photocopy bluefile and create labels per PPP D206-642-441

DOCUMENT CONTROL

Memo

100

Document Control

W/O:		,	W	ORK ORDER CHANG	ES				•
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQA:		_ Date:	
	R	esolution:	Dispositio	n:	_ QA: N/C Clo	sed:		_ Date: _	····
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR))			
DATE	STEP	Description of NC			ion B	Verifica	ation	Approval	Approval
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Page 2

August 4, 2010 2:32:51 PM

D206-642-441



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/04/10

QC:

Start Qty: 1.00

Required Date: 8/16/10

Req'd Qty: 1.00



Date: _____

Cust Item ID: Customer:

Reference:

	_	
An	provals:	

Process Plan:

Date:_____

Tooling:

0.00

0.00

SPC (Y/N):

Date: Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

110



Skidtubes

Skidtubes

Operation **Description**

Skidtubes

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as

required.

4-Grind weld flush to cap on top surface only.

A/R | Aluminum Rod | MI/4242/ MII 250 7



5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube







W/O:				WORK ORDER	CHANGES					*
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:		_ PAR #:	Fault Category:	NC	R: Yes	No DQ	A:	Date: _	
	R	lesolution:		Disposition:	QA	N/C	Closed:		Date: _	
NCR:				WORK ORDER NON-CON	IFORMANCE	(NC	R)			

NCR:			WORK ORDE	ER NON-CONFORMANG	CE (NCR)			
		Description of NC		Corrective Action Section B				Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspector
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Work Order ID 61043

August 4, 2010 2:32:51 PM



Page 3

Item ID:

D206-642-441

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/04/10

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Start Run

Reject

Qty

Stop



Sequence ID/

Required Date: 8/16/10

QC: ____

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Date:

Tool # Plan Code

Accept Qty

Reject Number

Insp. Stamp

Work Center ID

115

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Memo

Memo

0.00

116

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

120

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

10-8-11

Hand Finishing

W/O:			W	ORK ORDER CHANG	GES			•
DATE	STEP	PRO	OCEDÚRE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cat	legory:	NCR: Yes	No DQA:	Date: _	
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NCR:			WORK ORI	DER NON-CONFORM	IANCE (NCR)		
DATE	STEP	Description of NC	Initial		ction B	Verification		Approval
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Work Order ID 61043

Page 4

August 4, 2010 2:32:51 PM

Item ID:

D206-642-441

Revision ID:

Item Name:

Replacement Skidtube

Start Date: 8/04/10 Required Date: 8/16/10 Start Qty: 1.00 Req'd Qty: 1.00

QC:

Operation

Description



Accept

Run

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC3- Inspect Part Finish

Date: _____

Date:

Tooling: SPC (Y/N):

Set Up/

0.00

Run Hours

Date:

Date:

Start



Stop

Sequence ID/

Work Center ID

130

Memo

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

MB 10-08-12

Quality Control

Dail Ac	OSPace							
W/O:			WORK ORDER O	CHANGES				t
DATE	STEP	PROG	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date: _	
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		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector			
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Work Order ID 61043

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Item ID:

D206-642-441

Accept



Setup Start

Stop

Start

Stop

Reject



Revision ID:

Item Name:

Required Date: 8/16/10

Replacement Skidtube

Start Date:

8/04/10

Start Qty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling: QC:____

SPC (Y/N):

Date:

Tool # Plan

Code

Date:

Accept

Qty

Run

Number Stamp

Insp.

Sequence ID/ Work Center ID

140

Skidtubes

Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours**

0.00

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Memo

Start Date: 10 -8-12 Time: 10:45 AM

Finish Date: 10-18 16 Time: 17'. 40-1

A/R | Sikaflex-291 | 115/14 | Sikaflex expiry date: $\Box 11-1-30$

Reject

Qty

10-8-12

N/O:			WORK ORDER	CHANGES	·		<i>;</i>	•
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Part No	:	PAR #:	Fault Category:	NCR: Ye	es No DC	A:	Date: _	
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Work Order ID 61043

August 4, 2010 2:32:51 PM



Page 6

Item ID:

D206-642-441

Accept



Run

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/04/10

QC:

Start Oty: 1.00

Required Date: 8/16/10 **Req'd Qty:** 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Stop



Sequence ID/ **Work Center ID**

150

Quality Control

Operation Description

OC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

160

Skidtubes Skidtubes

Skidtubes

Memo

Memo

0.00

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the

other side. Use aluminum rod. A/R Aluminum Rod □ MII

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BC 10/08,

Dart Aeı	rospace L	_td						7	
W/O:			W	ORK ORDER CHANGE	ES				•
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK OR	DER NON-CONFORMA	NCE (NC	R)			
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Work Order ID 61043

Page 7

August 4, 2010 2:32:51 PM

Required Date: 8/16/10

Item ID:

D206-642-441

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/04/10

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

SPC (Y/N):

0.00

Date:

Date: ____

Start

Stop



Sequence ID/

Work Center ID

170

Skidtubes

Skidtubes

Operation Description

QC:

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Qty Qty

Run

Reject Reject Number

Insp. Stamp

HandFinishing

0.00 Install D2680-041 Nut Plate as per Dwg D2650

Date: _____

180

OC

Quality Control

OC10- Inspect visual per OS1004- ground welds

0.00

190

QC5- Inspect part completeness to step on W/O

Quality Control

Memo

Memo

				DI ODDED OUANOE		 			•
W/O:			WO	RK ORDER CHANGE	S		,		, ,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
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DATE		Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
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Work Order ID 61043

Page 8

August 4, 2010 2:32:51 PM

Required Date: 8/16/10

Item ID:

D206-642-441

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/04/10

Start Qty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:_____

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in

SPC (Y/N):

Tooling:

Tool ID

Date:

Tool # Plan

Code

Date:

Run

Start



Stop

Insp.

Stamp

Sequence ID/ **Work Center ID**

200

HandFinish

Operation Description

Pressure Wash per QSI005 4.3

Memo

Set Up/ **Run Hours**

10/08/20

Qty

Accept

Reject

Qty

Reject

Number

Hand Finishing

205

SprayPaint

Spray Painting

Memo

Spray paint Delfleet Blue Primer B 114424

Delfleet Blue B Clear delfleet B

0.00

0.00

0.00

206

Quality Control

QC14- Inspect Spray Paint

Memo

0.00

0.00

TI 10-09-07



W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRC	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	.	PAR #:	Fault Cat	egory:	NCR: Yes N	No DQA:	Date: _	
	Resolution: Disposition:							
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC			ion B	Verification	Approval	Approval
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Work	Orde	r ID	610	143
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Page 9

August 4, 2010 2:32:51 PM D206-642-441 Accept Item ID: Setup Start **Revision ID:** Stop Item Name: Replacement Skidtube **Start Date:** 8/04/10 Start Qty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 8/16/10 **Customer:** Reference: Start Run Process Plan: Date: **Tooling:** Approvals: Date: Stop Date: _____ QC: SPC (Y/N): Date: Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Operation Accept Reject Insp. Work Center ID **Description** Code Qty **Qty** Number Stamp **Run Hours** 230 0.00 HandFinishing HandFinish 0.00 10 109101 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside Hand Finishing insert holes before installing wearpad/wearplate. A/R DSikaflex-291 DV 11404 RD 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

Sikaflex expiry date: ☐ 10 110

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 \(\sigma\) Batch: M115028

Dart Ae	rospace	Ltd							
W/O:			W	ORK ORDER CHANGE	S				,
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	
	Re	solution:	Disposition: QA: N/C Closed:					Date:	
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section	n B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	1 -	ion C	Chief Eng	QC Inspector
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Work Order ID 61043

August 4, 2010 2:32:51 PM



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Item ID:

D206-642-441

Accept

Setup Start

Stop

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/04/10

Start Qty: 1.00

Required Date: 8/16/10

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Date:

Tooling:

SPC (Y/N):

Date: _____ Date:

Run Start



Sequence ID/

Work Center ID

240

Quality Control

Operation Description

OC:

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code Accept Qty

Reject **Qty**

Reject Number

Insp. Stamp

0.00 8 10109 W2

250

Packaging

Packaging

Memo

Memo

0.00

0.00

Identify and pack for shipping as per PPP D206-642-441 Packaging Location:

PPD 6/200

260

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/09 H

fulls/s

W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Picklist Print

August 4, 2010 2:32:55 PM

Work Order ID: 61043

D206-642-441 Parent Item:

Parent Item Name: Replacement Skidtube



Start Date: 8/04/10

Required Date: 8/16/10

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM

IPP Rev:1 08-05-01 add QC3 DD verified by:EC IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Mar	nufactured	No			·							
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10-8-12

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Picklist Print

August 4, 2010 2:32:55 PM

Page 2

Work Order ID: 61043

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3



Purchased

No

No

170

Each

532.0000

Cherry Rivet

D2649

Cross Bolt Spacer

D2680-041

Nut Plate

Manufactured

Manufactured

No

112314 113539

60 468 Each

Loc Oty

532

Loc Code 23 140.0000

23

Location Loc Qty LG 140 12 58545 60652 128 170 Each Loc Code

39.0000

BE 10/0/23

Location

Location

ST311



Loc Qty

Loc Code

Dart Ae	rospace	e Ltd							
W/O:			W	ORK ORDER CHANGE	S				,
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A :	Date: _	
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign 8		cation on C	Approval Chief Eng	Approval QC Inspector
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August 4, 2010 2:32:55 PM

Work Order ID: 61043 D206-642-441 Parent Item: Parent Item Name: Replacement Skidtube Required Date: 8/16/10 **Start Date: 8/04/10** Start Qty: 1.00 Required Qty: 1.00 ALS4-1032-130 No 230 3,842.000 60 Purchased Each 60 10/09/07 Insert Location Loc Qty Loc Code PKG11 3602 X60 114723 3602 ST282 201 110511 38 114407 163 ST381 39 114654 39 AN960JD10L NAS1149D0332J Purchased 230 Each 2,635.000 No 10/09/07 Washer Location Loc Qty Loc Code ST348 2635 X62 (10985 2635 NAS1149D0463J) Purchased AN960JD416 230 0.0000 No Each 10/09/07 Washer 11 15000 CR3212-4-03 1,926.000 Purchased No Each 2 Cherry Rivet Loc Code Location Loc Oty ST311 1926 111359 5 112314 2 114436 448 89 114450 114859 1382

W/O:			WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Category:	NCR: Yes	No I	DQA:	_ Date: _		
	R	esolution:	Disposition:	QA: N/C (Closed:		Date: _		
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NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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August 4, 2010 2:32:55 PM

Work Order ID: 61043

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Plug

No Manufactured

230

Each

748,0000

Loc Code

22

DI 10/04/07

D2651-3

Manufactured No fpa (53349 57869

51530

Location

FP

230

Loc Qty

356.0000

x 27. 22

10/09/07

O-Ring

D3535-15

Manufactured No FP 46114

Location

356 356 230 Each

Loc Oty

10.0000

Loc Code

Loc Code

y22

M 10/09/07

D3535-23

Wearshoe

Wearshoe

Manufactured No Location FP18

69236

57730

Loc Oty 10 10

Each

1.0000

Folpolo1 PM

Location FP21

Loc Qty

230

Loc Code

B60861

Dart Ae	rospace	Ltd									
W/O:			V	ORK ORDER CHAN	GES				,		
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #:									
·	Re		WORK ORDER NON-CONFORMANCE (NCR) Date: Disposition: Date:								
NCR:			WORK OR	DER NON-CONFORM	IANCE (N	CH)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	_		erification Section C	Approval Chief Eng	Approval QC Inspector		

August 4, 2010 2:32:55 PM

Work Order ID: 61043 D206-642-441 Parent Item: Parent Item Name: Replacement Skidtube **Start Date: 8/04/10** Required Date: 8/16/10 Start Qty: 1.00 Required Qty: 1.00 D3535-37 230 Manufactured Each 17.0000 11 10/09/07 Wearshoe Location Loc Qty Loc Code FP 17 4 13 D3536-15 230 25.0000 Manufactured Each Jul 10/09/07 Gasket Location Loc Qty Loc Code FP 18 56055 6 60875 12 FP11 7 50238 7 D3536-23 Manufactured 230 Each 14.0000 Gasket Location Loc Oty Loc Code FP011 14 2 58819 12 60234 D3536-37 Manufactured 230 Each 15.0000 Gasket Loc Qty Location Loc Code 15

56102

13516417

W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Mgr	
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Part No:	·	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	Resolution: Disposition:					osed:		Date:	
NCR:		\	WORK OR	DER NON-CONFORMA	NCE (NCR	3)			
		Description of NC Corrective Action			on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector
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August 4, 2010 2:32:55 PM

Work Order ID: 61043 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube D3537-1



Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00 Required Qty: 1.00

H 10/09/07

Wearpad

Manufactured

No

Manufactured No Location Loc Qty Loc Code 55465 136-1201 FP17 57713 3 3 59593 230 Each 16.0000

Each

230

70/20/01 LM

Wearpad

D3537-3

Screw

MS27039-1-08 Purchased No Location FP19

FP

Loc Oty 16 16 Each

1,763.000

Loc Code

Loc Code

7.0000

10/09/01

Screw

MS27039-4-06 Purchased

No

Location Loc Qty ST291 1763 110835 563 114718 200 115108 1000 230 Each

230

25.0000

Location ST292

109061

Loc Qty 25 25 Loc Code

			WORK ORDER CHANGES						
W/O: DATE	STEP	PR	OCEDURE CHANGE	By	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Dort No.		DAD #-	Foult Cotogony	NCR: Yes	No DO	Δ.	Data		
Part No			Fault Category: Disposition:						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng				
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Picklist Print

August 4, 2010 2:32:55 PM

Work Order ID: 61043

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube

Purchased

No

MS27039C1-08

SCREW



230

Start Date: 8/04/10

Required Date: 8/16/10

Page 7

Start Qty: 1.00

Required Qty: 1.00

1,058.000 60

M 10/09/07

Location	Loc Oty	Loc Code	
FP	1000		
1 5336	1000		<u> </u>
ST293	58		
19185	58		

Each

W/O:		WORK ORDER CH	WORK ORDER CHANGES					
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STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Description A Description A Description A Description Section B Section C

QTY QTY QTY PART NUMBER DESCRIPTION Х D2650-1 SKIDTUBE ASSEMBLY X D2650-3 SKIDTUBE ASSEMBLY X D2650-5 SKIDTUBE ASSEMBLY X D2650-7 SKIDTUBE ASSEMBLY D2600-1-160 **EXTRUSION** D2654-1 WEB D2654-3 WEB D2654-5 WEB D2654-7 WEB D2646 AFT CAP D2647 CAP 17 18 19 23 D2649 CROSS BOLT SPACER 16 18 14 22 D2651-1 PLUG 16 18 14 22 D2651-3 O-RING D2680-041 NUT PLATE 2 2 D3286-1 DOUBLER 2 2 D3286-3 STUD 42 44 54 ALS7-1032-130 INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) 2 2 2 2 AN960JD10L WASHER 2 2 2 2 CCR264SS3-3 RIVET 2 2 2 2 CR3212-4-03 RIVET 2 2 2 2 MS27039-1-08 SCREW 1 MS27039-4-06 SCREW 1 AN960JD416 WASHER 52 52 CR3212-4-04 RIVET

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SHO believe A RETTING NO ENGINETERNIC UNCONTROLLED COPY SUBJECT TO AMENEMENT WITHOUT KOPEE

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В

/F` NOTES:

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2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

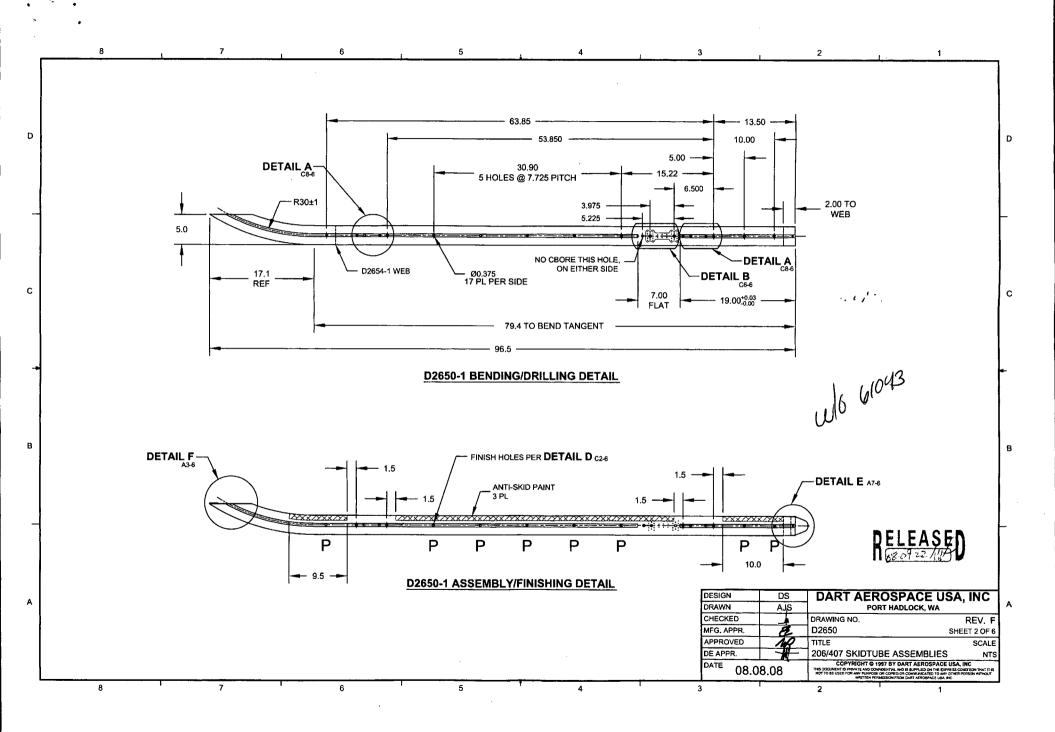
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

	DRAWING UPDATED TO CURRENT STANDARDS. SHT		I
F	6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	СР	04.05.17
С	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
В	AS MANUFACTURED CHANGES	DS	97.06.26
Α	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE

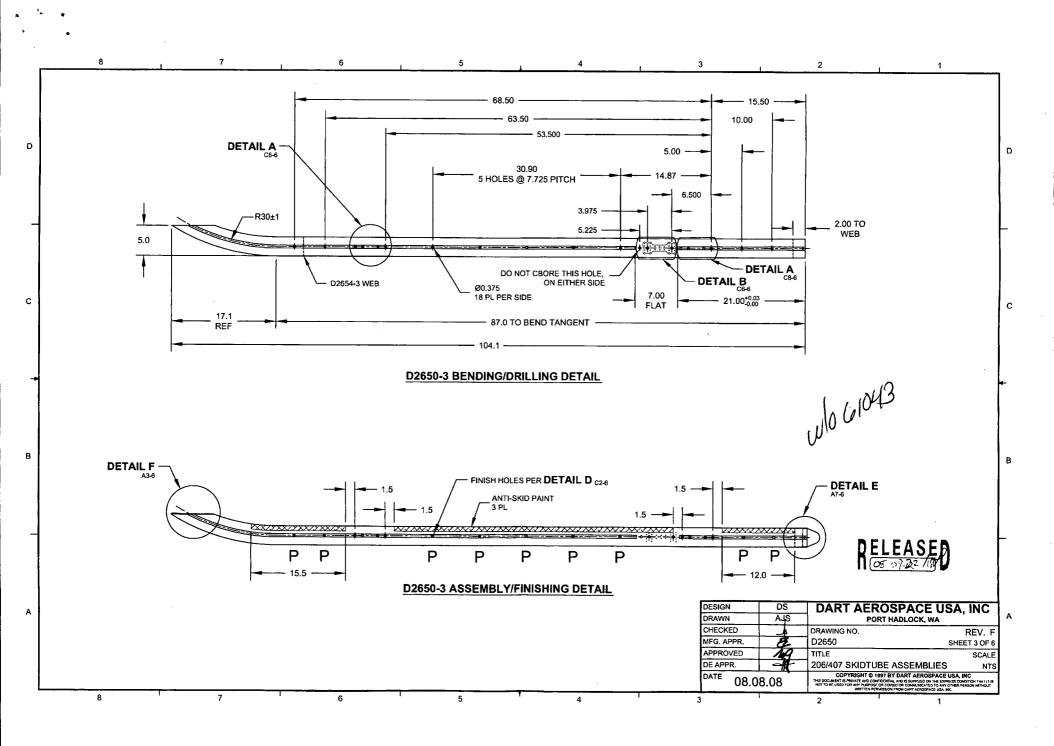
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DRAWN	AJIS	PORT HADLOCK, WA	
CHECKED	4	DRAWING NO. R	EV. F
MFG. APPR.	8	D2650 SHEET	1 OF 6
APPROVED	10	TITLE	SCALE
DE APPR.	-	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE 08.0	8.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS REMATE AND CONDIDENTIAL AND IS SUFFLIED ON THE EXPRESS CONCENTE HIGH TUBE LIBER DEPORT OF CONSIDERATION OF CONTRACT OF THE PROPERTY OF THE PROPER	N THAT IT AS

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			Dispositio	n:	QA: N/C CI						
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DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector		
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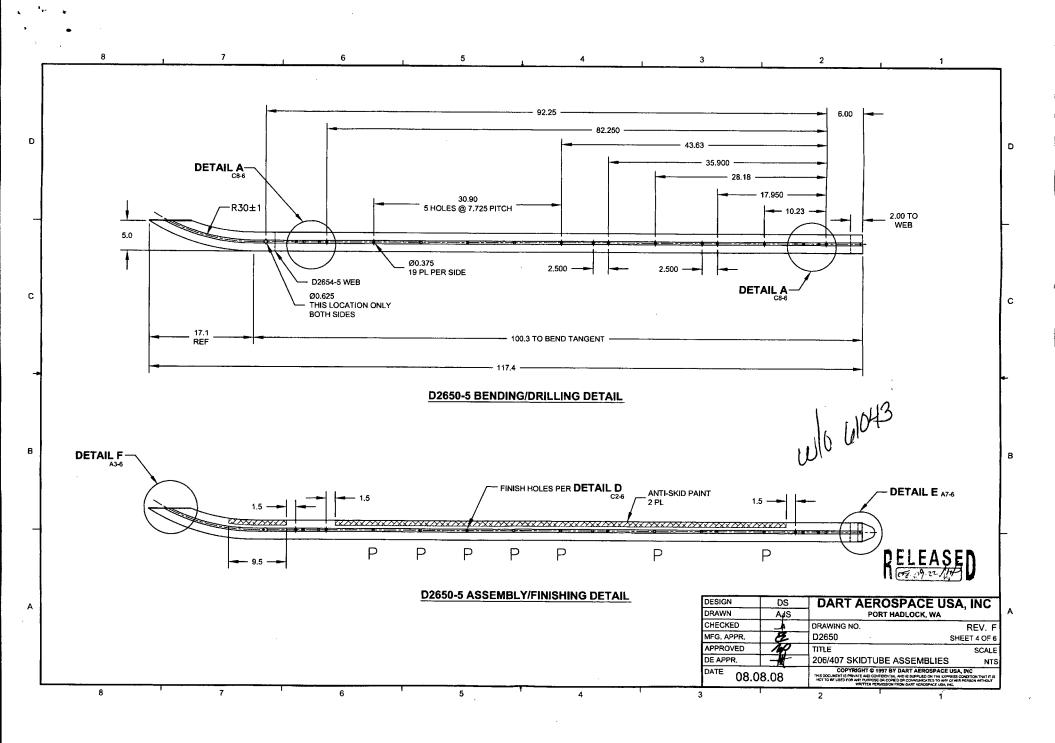


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DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section (C Chief Eng	QC Inspector					

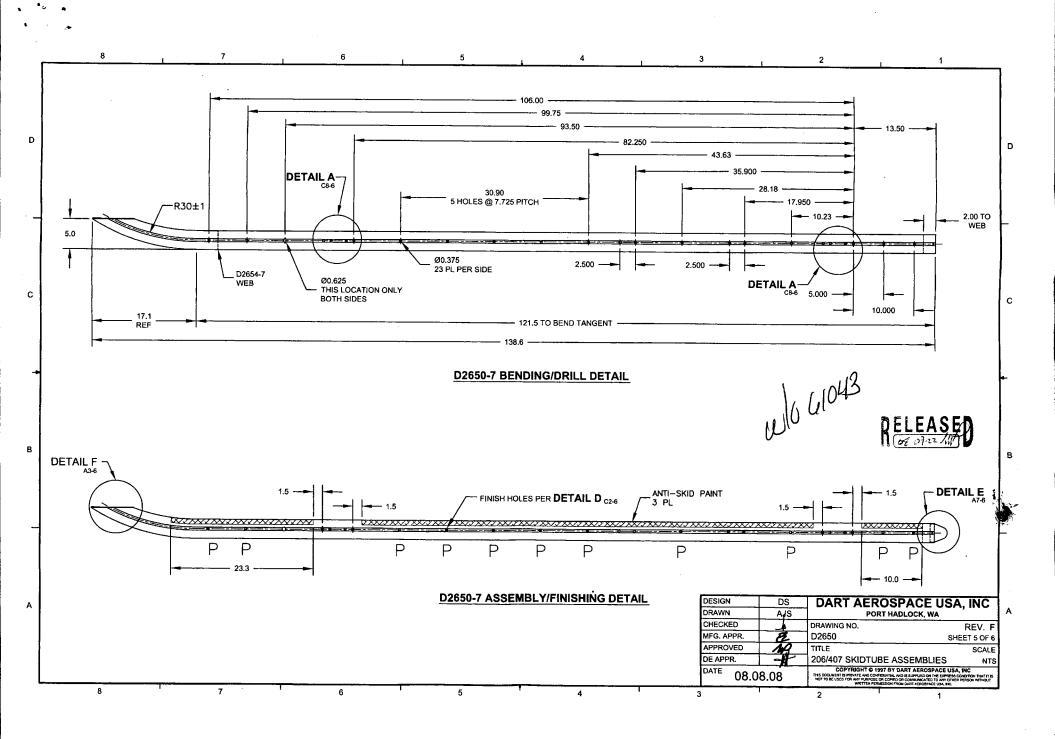


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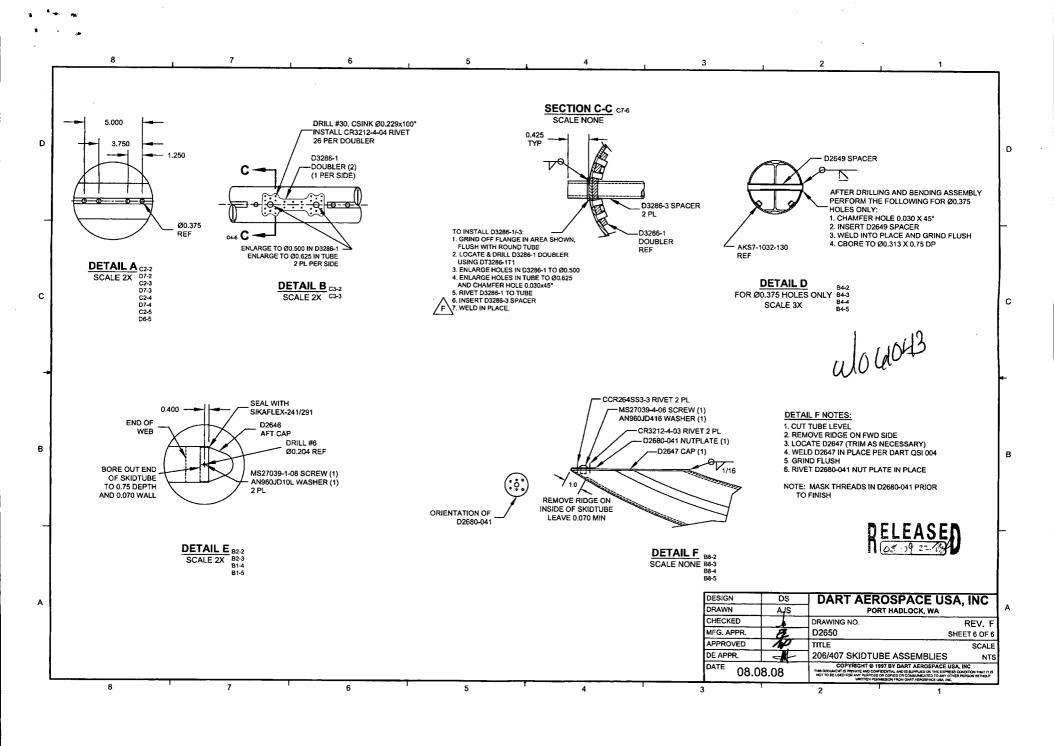
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AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: forclas Elliott
Job number: 639
Part number: Dade HID 441
Description: 206 Skid tube
Welding Process: Tig[/] Mig[]
Base materiel: Aluminium
Current: AC[/ DC[]

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[/] fail[] pass[] fail[]
UNACCEPTABLE	
Cracks:	pass[/ fail[]
Undercut:	pass[// fail[]
Pin holes:	pass[fail[]
Overlap (cold lap)	pass[], fail[]
Porosity (surface):	pass[/ fail[]
Coloration:	pass[] fail[]
Qualifier Del Del	Date of Test Coupon 10 02 19
Welder Horley Elliat	Date of Test Coupon_ <i>i0.08.19</i>

The above named individual is qualified in accordance with AWS D17.1.2001 to weld